

Work Order ID 94410

94410

ASAP

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Monday, December 17, 2012 1:40:44 PM

Item ID: D3137-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Washer
 Start Date: 12/17/2012 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 12/17/2012 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: MUP Date: 12-12-17 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3137	Rev F

100		0.00							
100	Hardinge CNC LATHE SMALL								
Hardinge	Memo	0.00	12/12/17	12					
Hardinge CNC Lathe Small	1-Machine as per Folio FA471 and Dwg D3137 2-Identify as D3137-5 3-Deburr								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00	12/12/17	12					
Quality Control									

120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00	12-12-17	12					
Quality Control									

DAS
04
9-89

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Item ID: D3137-5 Accept *N900040100* Setup Start *NS1*
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 Start Date: 12/17/2012 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 12/17/2012 Req'd Qty: 12.00 *12* Customer:
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Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <i>SA</i>	0.00							
160									
Packaging	Memo	0.00							
Packaging									

12 X *mk*
 12/12/17

12 *1212-17*

12 *SA*
 12/12/17

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Item ID: D3137-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Washer

Stop ***NS2***

Start Date: 12/17/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 12/17/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/12/18 *[Signature]**MF*

12-12-18

Picklist Print

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Work Order ID: 94410

Parent Item: D3137-5

Parent Item Name: Washer

Start Date: 12/17/2012

Required Date: 12/17/2012

Start Qty: 12.00

Required Qty: 12.00

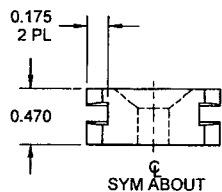
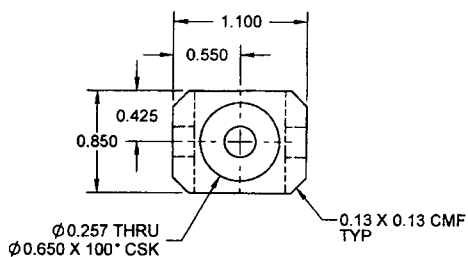
Comments: IPP A04.11.04New issueKJ/JLM
IPP Rev B 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750 6061-T6 Round Bar .750"		Purchased	No			100	f	70.5180	0.0208	0.2627368	0.379	12/12/17	

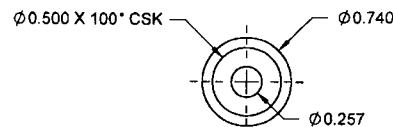
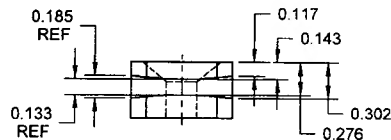
Location	Loc Qty	Loc Code
MAT012	13	
120734	13	
MAT013	57.518	
121282	9.024	
122081	26.494	
→ 123757	22	

NOT
Pulled

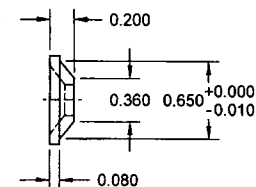
0.379



D3137-3 GUIDE



D3137-5 WASHER



NOTES:

- 1) MATERIAL: -3
DELTRIN II 150E OR ACETRON GP ACETAL, BAR
(REF DART SPEC M-DELTRIN-B)
-5
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)
OR PER-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207
-5 REPLACES PREMIER P/N B30-2300-209

RELEASED

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JAS		
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	J	D3137	SHEET 5 OF 5
APPROVED	J	TITLE	SCALE
DE APPR.	J	BRACKET ASSEMBLY	NTS
DATE	08.05.30	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

